

Work Order ID 117021

117021

Page 1

April-24-14 9:06:44 AM

Item ID: D4803-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar Assembly, Sway
 Start Date: 5/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-04-28 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4803	<u>A</u> <u>B</u> <u>C</u>	<u>AN 4.06.18</u>							

110 0.00

110 2 FF Dec-15-2014

Small Fab Memo 0.00
 Small Fab ALIGN PILOT HOLES IN D4803-1 WITH PILOT HOLES IN D4869-1 AND D4806-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9976 AS PER DWG.

120 QC5- Inspect part completeness to step on W/O 0.00

120 (2) 38
 QC 9-89

Quality Control Memo 0.00

DEC 15 2014

punch. issue P/O to P+L P/O: 26854 C/L 14/12/18 2
 rec'd. 2x 8015-01-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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April-24-14 9:06:44 AM

Page 2

NS1

NS2

*** 1 ***

*** 1 ***

NR1

NR2

Date:

**Insp.
Stamp**

②

DAS
38
9-89

DEC 16 2014

0.00

2x

DAS
28
9.85

JAN 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 117021

117021

Page 3

April-24-14 9:06:44 AM

Item ID: D4803-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bar Assembly, Sway
Start Date: 5/02/14 Start Qty: 1.00 ** Cust Item ID:
Required Date: 5/02/14 Req'd Qty: 1.00 ** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21 - Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLD 1501-23

DB-1-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

April-24-14 9:06:48 AM

Page 1

Work Order ID: 117021

117021

Parent Item: D4803-041

D4803-041

Parent Item Name: Bar Assembly, Sway

Start Date: 5/02/14

Required Date: 5/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.01.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

HL20PB5-8		Purchased	No				Each	76.0000		4			
HI 20PB5-8									**		FF	DEC 16 2014	
Rivet													

HL32PB5-8
u

Location	Loc Qty	Loc Code
ST281	66	
M128110	6	
M128579	60	
ST284	10	
M128429	10	

129865

D4803-1		Manufactured	No				Each	0.0000		1			
D4803-1									**	2	FF	14-07-31	
Strut													

D4806-1		Manufactured	No				Each	2.0000		1			
D4806-1									**	04	FF	14-07-31	
Clevis													

116507

Location	Loc Qty	Loc Code
ST123	2	
112026	2	

116513

D4806-3		Manufactured	No				Each	3.0000		1			
D4806-3									**		FF	14-07-31	
Stud													

Location	Loc Qty	Loc Code
ST123	3	
115957	3	

117319

2

DQA: _____ Date: _____



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Training									
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Picklist Print

Page 2

April-24-14 9:06:48 AM

Work Order ID: 117021

117021

Parent Item: D4803-041

D4803-041

Parent Item Name: Bar Assembly, Sway

Start Date: 5/02/14

Required Date: 5/02/14

Start Qty: 1.00

Required Qty: 1.00

D4869-1 Manufactured No

Each 2.0000 1

D4869-1

**

FF 14-07-31

End Fitting, Eye

Location

Loc Qty

Loc Code

ST131 116536
116167

2
2

2

HL86-5 Purchased No

Each 113.0000

4

HI 86-5

**

FF DEC 16 2014

Collar

Location

Loc Qty

Loc Code

ST280 1129864
M128110
ST284
M128228

16
16
97
97

8

NAS509-6C Purchased No

Each 19.0000

1

NAS509-6C

**

FF 14-07-31

Nut

Location

Loc Qty

Loc Code

ST276
M128110
M128429

19
9
10

2

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26854**

Purchase Order Date 12/18/2014

PO Print Date 12/18/2014

Page Number 1 of 3

Order From :

VC-PL001

Ship To : DART AEROSPACE LTD

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-931-1241

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect



Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	117156 LASER MARKED	D4804-041 BIPOD ASSEMBLY	12/23/2014 Yes 12/23/2014		1.00	\$4.00	\$4.00
Line Total:							\$4.00
2	121379 LASER MARKED	D4868-042 LEG ASSEMBLY	12/23/2014 Yes 12/23/2014		2.00	\$4.00	\$8.00
Line Total:							\$8.00
3	117021 LASER MARKED	D4803-041 BAR ASSEMBLY	12/23/2014 Yes 12/23/2014		2.00 ✓	\$4.00	\$8.00

8815-01-20

Note:

12/18/2014

Tel. 613-931-1241
Fax 613-931-2560
piprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE January 14, 2015

P.O NUMBER **PO26854**

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4804-041 BIPOP ASSEMBLY	1	ALL ITEMS HAVE BEEN LASER MARKED
D4868-042 LEG ASSEMBLY	2	
D4803-041 LEG ASSEMBLY	2	
D4868-041 LEG ASSEMBLY	2	
D4834-042 LEG ASSEMBLY	2	



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-831-1241
Fax 613-831-2560
plprinting@bellnet.ca

Invoice

Number: 7524

Date: January 14, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
26854		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4804-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4868-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4803-041 ✓	2.00	4.00	✓	8.00
Laser Metal Marking, D4868-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4834-042	2.00	4.00	✓	8.00
Sub-Total				\$36.00
				13.00% on 36.00
				Total \$40.68

8015-01-20

Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You